

Date Thursday, 16/08/2007 11:32:16 AM
User Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BUSHING		
Job Number	: 34019			Part Number	: D28063		
Estimate Number	: 10518			Drawing Number	: D2806 REV A		
P.C. Number	: N/A			Project Number	: N/A		
This Issue	: 16/08/2007	S.O. No.	: N/A	Drawing Revision	: A		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: N/A			Due Date	: 05/09/2007		
Previous Run	: 29847			Qty:	30	Um:	Each
Written By	: <u> </u>						
Checked & Approved By	: <u> </u>						
Comment	: Est:B 05.03.11 Part now turned KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6H1000	6061-T6 1" HexBar 
	Comment: Qty.: 0.0962 f(s)/Unit Total : 2.8854 f(s) 6061-T6 Hex Bar 1.0" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar (M6061T6H1.000)	 H.A 08/01/02 Batch: M 105238
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 
	Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA105 and Dwg D2806 2-Tumble	 H.A 08/01/02
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 H.A 08/01/02
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
	Comment: CONVENTIONAL MILLING MACHINE Drill as per Dwg D2806	 70 08/01/08 30
5.0	QC8	SECOND CHECK 
	Comment: SECOND CHECK	 50 08/01/08 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 08/01/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:32:17 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 34019

Part Number: D28063

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 08-01-11 (30)

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

MR. B 08/01/12 (30X)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST48

Final Inspection/W/O RELEASE

PSK/14 (30)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 8/01/15 (30)

Job Completion



U 88-01-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

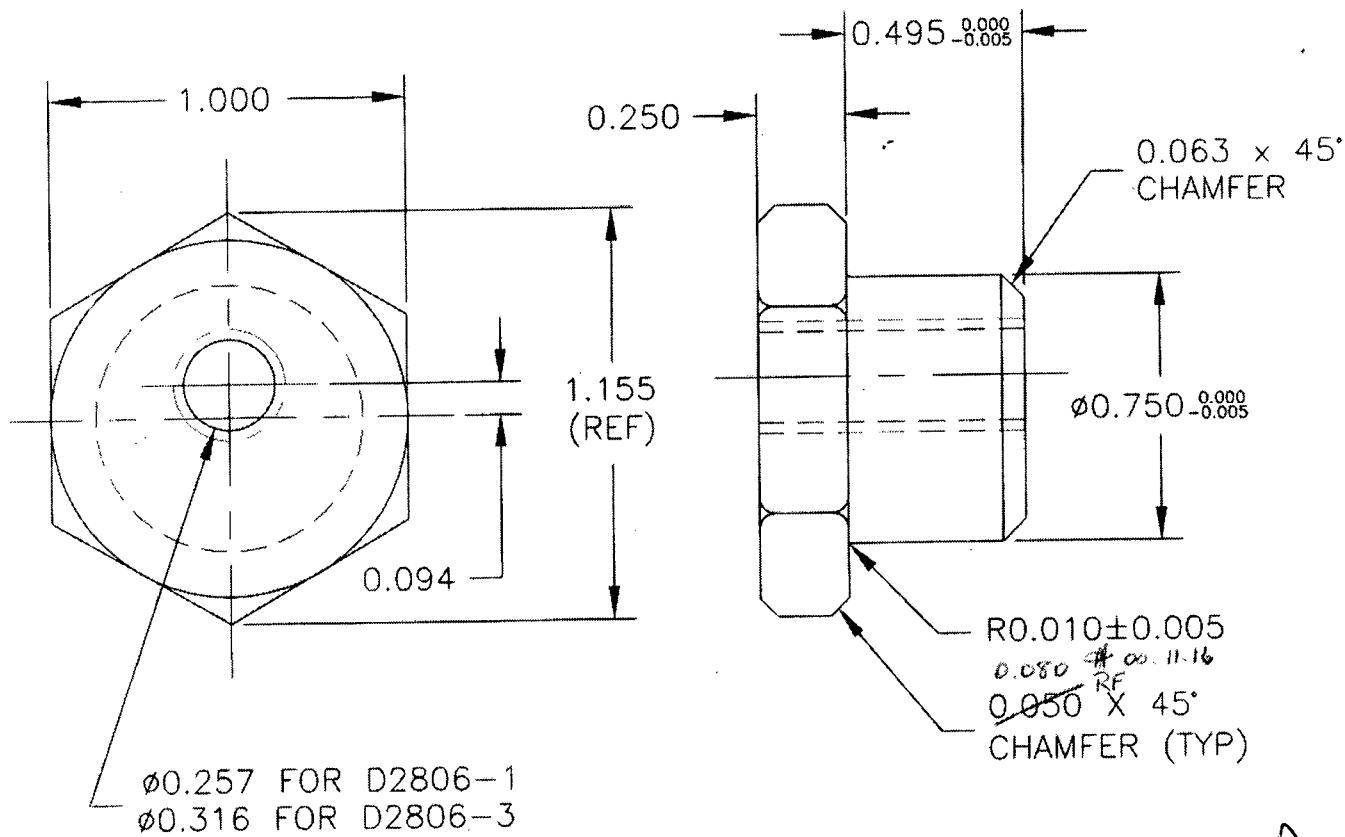
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2806	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.08		BUSHING	2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.12



D2806-1 (DRILL Ø0.257 HOLE)
D2806-3 (DRILL Ø0.316 HOLE)

WFO 34019

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD	Work Order:	34014
Description: Bushing	Part Number:	D2806-3
Inspection Dwg: D2806	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>J.A. / JMK</u>	Audited by:	<u>SA</u>	Prototype Approval:	N/A
Date:	<u>08/01/02</u>	Date:	<u>08/01/08</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	